

Date: Thursday, 31/07/2008 12:17:57 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT			
Job Number	: 40846						
Estimate Number	: 10277						
P.O. Number	:		Part Number	: D2565105			
This Issue	: 31/07/2008	S.O. No. :	Drawing Number	: D2565 REV E			
Prsht Rev.	: NC		Project Number	: N/A			
First Issue	: / /		Drawing Revision	: E			
Previous Run	: 38029		Material				
Written By			Due Date	: 07/08/2008			
Checked & Approved By	<u>JLD</u> 08.8.01		Qty:	10 Um: Each			
Comment	: Est: F02.04.16 Added dwg Rev.C1 NG						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 1.7666 f(s)/Unit Total : 17.6663 f(s) 304 RD TUBE .750 X.49W Punch 304/316/318-2B Seamless Tubing, 3/4" O.D. x 0.049" wall to length as per Dwg D2565 using DT 8313 Batch <u>M108846</u> (M304TR0750W049)	
2.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Punch as per Dwg D2565 using DT 8313	
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill hole open to .316 Ø as per Dwg D2565 (one end only) Deburr	
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	
5.0	POWDER COATING	POWDER COATING	
		Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3	
	START TIME: OVEN TEMPERATURE: FINISH TIME:	7:45 400° 8:15	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2565-105 PAR #: N/A Fault Category: Prod/finishing NCR: No DQA: Date: 08/08/10
QA: N/C Closed: Date: 08/09/11

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/8/08	5.0	2 scratches were found to have markings on them from the material	J QSIUR	Scuff with 320 grit sand paper. and clean with red scratch brite and acetone.	FL <input checked="" type="checkbox"/> 08/09/08	<input checked="" type="checkbox"/> QSIUR	<input checked="" type="checkbox"/> QSIUR	<input checked="" type="checkbox"/> S scratches
		2.1. Scratches were not scratches cleaned enough.	J QSIUR	Re Powder coat as per QSIUR 5.	FL 08/09/08 <input checked="" type="checkbox"/>	<input checked="" type="checkbox"/> QSIUR	<input checked="" type="checkbox"/> QSIUR	<input checked="" type="checkbox"/> S scratches

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



108

Comment: INSPECT POWDER COAT

M-1

08/09/08

7.0 PACKAGING 1

PACKAGING RESOURCE #1



108

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 270

8/10/08

SP

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/10 SP

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-09

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

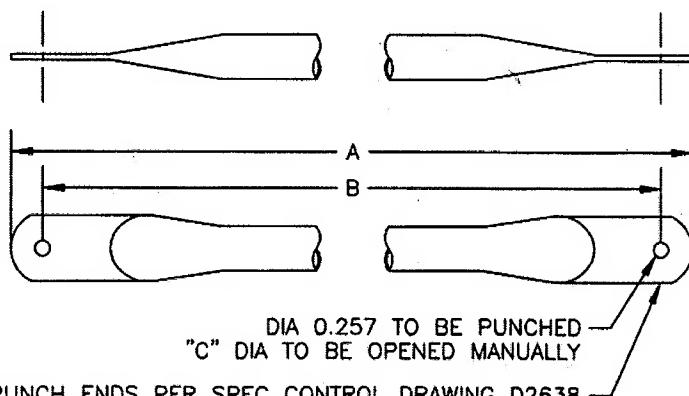
NOTE: Date & initial all entries



1 COPY ISSUED
10 ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2565	SHEET 1 OF 1
DATE		TITLE	SCALE
04.05.05		STRUT	1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05



PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	—
D2565-109	12.31	11.51	—
D2565-111	13.65	12.85	—
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	—
D2565-209	15.16	14.36	—
D2565-211	14.14	13.34	—
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	—
D2565-309	20.17	19.37	—
D2565-311	16.30	15.50	—
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	—
D2565-409	9.34	8.54	—
D2565-411	13.81	13.01	—

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40846